

Work Order ID 64416

Monday, December 06, 2010 8:17:41 AM

Page 1

Item ID: D2012-113

Accept

Setup Start

Revision ID:

Item Name: Clamp

Stop

Start Date: 12/6/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-6

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2012-113

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2012-113

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

304.63

B10-12-6

30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-12-6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Scrap 12/06

10 units
x36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 64416

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Item ID:	D2012-113	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Clamp					
Start Date:	12/6/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	12/13/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00				(36X)		B10-12-7	(30)
Small Fab	Memo	0.00							
Small Fab	1- Deburr any rough edges 2- Bend as per Dwg D2012-113 using DT8458 3- Tumble								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150  Packaging	Identify as per dwg & Stock Location: <i>CUY</i>	0.00							
Packaging	Memo	0.00							

= 7 m-k 10/12/07

8.10.12.07

causes

(36)

10/12/7 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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Work Order ID 64416


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Item ID: D2012-113 Accept  Setup Start 
Revision ID:
Item Name: Clamp Stop 
Start Date: 12/6/2010 Start Qty: 20.00  Cust Item ID:
Required Date: 12/13/2010 Req'd Qty: 20.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/12/8 
ME
10-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 8:17:45 AM

Page 1

Work Order ID: 64416

Parent Item: D2012-113

Parent Item Name: Clamp





Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: F01.10.05 Fixed Typo and Added Inspection Level 21 SM
IPP Rev:G Now on Waterjet 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			110	sf	125.7000	0.015	0.315789	16		
304/316 Sheet .063											1810-12-6		

Location

Loc Qty

Loc Code

MAT

125.7

111323

0

115688

1.7

115953

124

115688

36

W/O:		WORK ORDER CHANGES					
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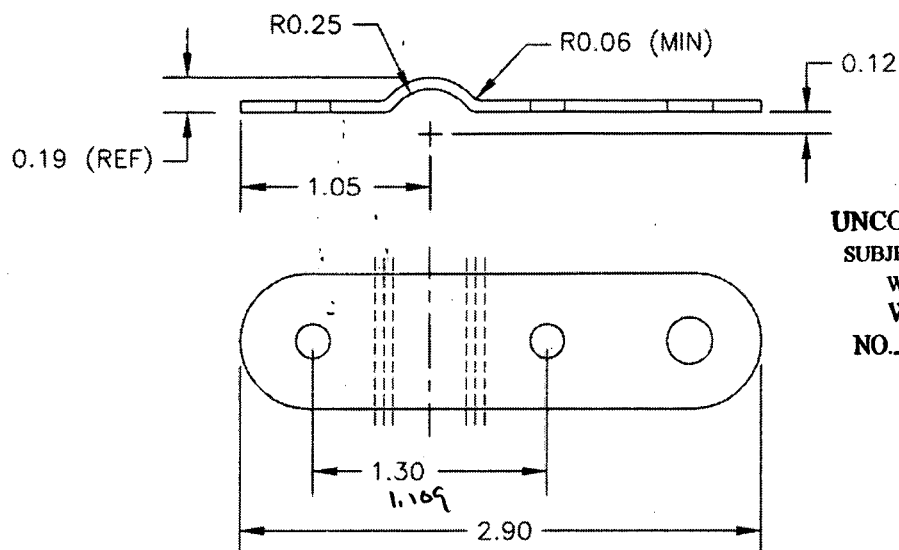
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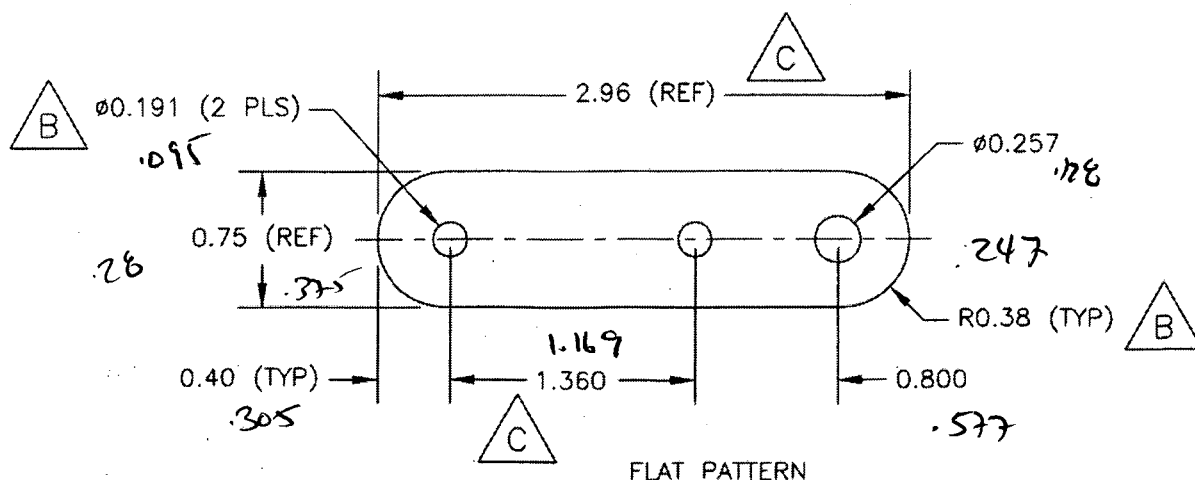
DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-113	REV. C SHEET 1 OF 1
DATE 00.04.28		TITLE CLAMP	SCALE 1:1
A	92.06.03	REDRAWN FROM D2012	
B	00.02.23	REDRAWN; R0.38 WAS R0.50; $\phi 0.191$ WAS $\phi 0.189$; ADDED FLAT PATTERN	
C	00.04.28	2.96 WAS 3.35; 1.360 WAS 1.745	

RELEASED
00.05.02



BENT DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *014116*
B/H-12-6



FLAT PATTERN

MATERIAL: AISI 304/316 SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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